

# Work Order ID 86754

**\*86754\***

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Item ID: D2322 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Spacer  
 Start Date: 7/06/12 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date: 12-07-9 Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***


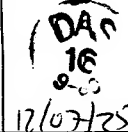
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2322	Rev C					57			

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C 2-  
 Deburr if necessary  
 2034.040  
 B12-7-24

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control  
 B12-7-24

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control  
 26 →  
 took qty of 1 Part  
 for inspection  
 DAS 16 9-89  
 12-7-25  
 17/07/25

# Dart Aerospace Ltd

W/O: 86754		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/07/25	# 120	took Qtr 1 For QC inspection template	S	12/08/17	(H)	 12.08.17	 12/07/25

Part No: D 2322    PAR #:    Fault Category:    NCR: Yes No    DQA:    Date:     
 Resolution:    Disposition:    QA: N/C Closed:    Date:   

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action    Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D2322	0.00  0.00				26			SB 12/08/15
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				26			SMB 12-8-15 (DAS 16 2-83) 17/06/15 26 can't
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				26			26 12-8-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86754

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 Start Date: 7/06/12 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00							
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location <b>GA</b>  Memo	0.00 0.00							
180 <b>*180*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

**DAS 16**  
9-3-16

**nd**

**st 12/08/16**

**MLJ 12/08/17**  
**MLJ 12/08/17**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 86754

Parent Item: D2322

Parent Item Name: Step Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 05-11-07 JLM  
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	0.203	5.1284208			

12-7-24

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

(27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
BW	CP	DRAWING NO.	D2322	REV. C
CHECKED KE	APPROVED [Signature]	DATE	98.09.29	SHEET 1 OF 1
DATE		TITLE	STEP SPACER	SCALE
98.09.29		STEP SPACER	NEW ISSUE	1:2
A	94.10.14	4.428 WAS 4.460, 0.040 WAS 0.032		
C	98.09.29	CHANGES PER NCR 001		

RELEASED  
18.10.08 DS

UNDER REVIEW

01.03.15 CP

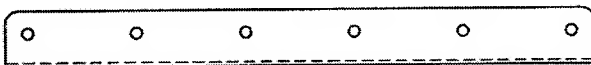
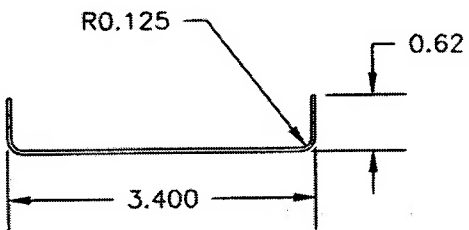
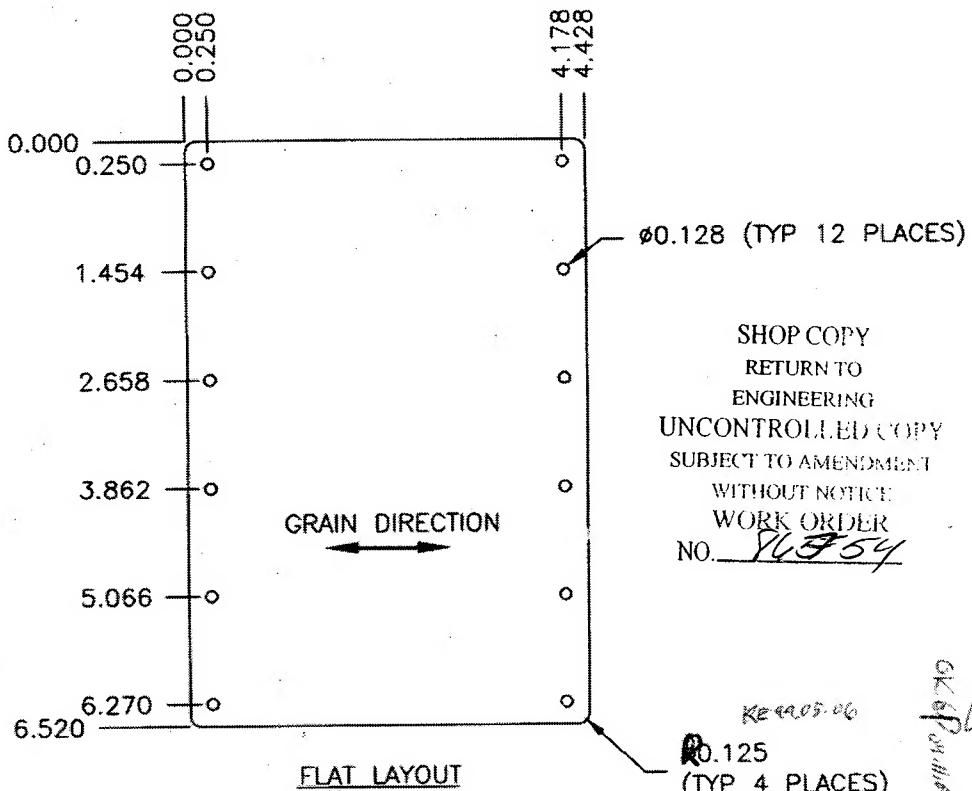
DESIGN OK, BUT CHECK WITH  
DJS BEFORE MANUFACTURE

OK 01.03.15

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. PL 54

KE 98.09.06

R0.125  
(TYP 4 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries